

Work Order ID 70853

Thursday, June 16, 2011 2:20:40 PM



Page 1

Item ID: D3943-051

Accept



Setup Start



Revision ID:

Item Name: Handle Assembly

Stop



Start Date: 6/16/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 6/16/11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3943

1 D

100

Weld per dwg A/R Steel rod Batch: M9326

0.00



Large Fab

Memo

0.00

Large Fab

Assemble with handle as per dwg

EL 16-9-15 15

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5 0 BE 11/09/15

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

5 0 BE 11/09/15

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Stop



Sequence ID/
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Tool #

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Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Hybrid safety Yellow 4.3.5.12

0.00



Powdercoat

Memo

0.00

Powder Coating

1- MASK THREADS PRIOR TO PAINTING AS PER DWG

2- POWDER COAT:

Start Time: _____

Oven Temperature: _____

Finish Time: _____

10:50
400°F
11:20

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: W/B

0.00



Packaging

Memo

69900

0.00

Packaging

5x Ø m - 7/10/20

5 BR 11-9-20

12 11-9-26 XS

M11632N

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/27

MF 11-09-26

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Picklist Print

Thursday, June 16, 2011 2:20:47 PM

Page 1

Work Order ID: 70853

Parent Item: D3943-051

Parent Item Name: Handle Assembly



Start Date: 6/16/2011

Required Date: 6/23/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: add DEO DD 09.11.18 verified by:JLM IPP Rev:B as per
dwg REV.C DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3943-5		Manufactured	No			100	Each	15.0000	1	6			
Plate												EL 11-9-15	

Location	Loc Qty	Loc Code
----------	---------	----------

ST095	15	
69062	4	
70026	11	

D3943-7		Manufactured	No			100	Each	29.0000	2	12			
Stud												EL 11-9-15	

Location	Loc Qty	Loc Code
----------	---------	----------

ST095	23	
52980	1	
70027	22	
WA	6	
69044	6	

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ITEM No.	QTY -041	QTY -051	QTY -053	PART NUMBER	DESCRIPTION	PREFERRED SUPPLIER
1	X			D3943-041	GROUND HANDLING CRANK ASSEMBLY	
5	1	X		D3943-051	HANDLE ASSEMBLY	
6	1		X	D3943-053	CHAIN ASSEMBLY	
11		1		D3943-1	HANDLE	M/F HANDLE FROM DIS-ASSEMBLED ITEM 39
12	1			D3943-3	HANDLE EXTENSION	
13		1		D3943-5	PLATE	
14		2		D3943-7	STUD	
15			1	D3943-9	CHAIN	USE CHAIN SUPPLIED WITH ITEM 39
16			1	D4405-1	EYE AND FORK SWIVEL	
21	1			D2690-4	LANYARD	
22	1			D3585-1	SET SCREW	
23	1			D3949-041	REMOVE BEFORE FLIGHT FLAG	
24			1	D3954-5	CHAIN LUG	
25	1			D3954-7	RATCHET LUG	
26			1	D3954-9	GWT CHAIN PIN	
31	1			AN5-11A	BOLT	
32	1			AN960-516	WASHER	
33	1			MS21042L5	NUT	
39	1			8143919	LEVER CHAIN HOIST (POWER FIST)	PRINCESS AUTO / 4000 lbs CAPACITY
51	1			S-1475	SPRING	REID SUPPLY
52	1			3408A59	BALL PLUNGER	McMASTER CARR
53	1			HX-15	SOCKET HEAD CAP SCREW 1/2-20 UNC X 0.75 LG	HASKINS
54	1			HX-16	SOCKET HEAD CAP SCREW 1/2-20 UNC X 1.0 LG	HASKINS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 10853

RELEASED
2011-05-24
WJP

D	SHT 1 PL, ITEMS 51-54 RENUMBERED SEE PREV. REV. FOR DETAILS, ITEM 16 ADDED (VIEWS UPDATED), SHT 2 ZN D3 FLAG RELOCATED, SHT 3 ZONE D3, Ø0.12 HOLE DELETED. (SEE NCR 11-495)	AJS	11.05.16
C	RMV FINISH -041 (ZN A8-2), ADD NEW FINISH -051/-053/-1/-3 (A8-3/-4/-5), ADD CALIBRATION (A8-2), (1) HX-16 WAS HX-15 (B3-1, C3-1), PAR 10-001	CP	10.01.26
B	SHT 1 PL, ITEM 31 WAS AN4-10A, ITEM 32 WAS AN960-416, ITEM 33 WAS MS21042-4, ITEM 43 WAS 0.75 LG. SHEETS 2 - 5 NOTES: FINISH FOR ALL COMPONENTS NOW YELLOW SPRAY PAINT.	AJS	09.10.15
A	NEW ISSUE	AJS	09.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	DSTOW / AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3943 REV. D SHEET 1 OF 5 TITLE GROSS WEIGHT TOW CRANK ASSY SCALE NTS <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.05.16		

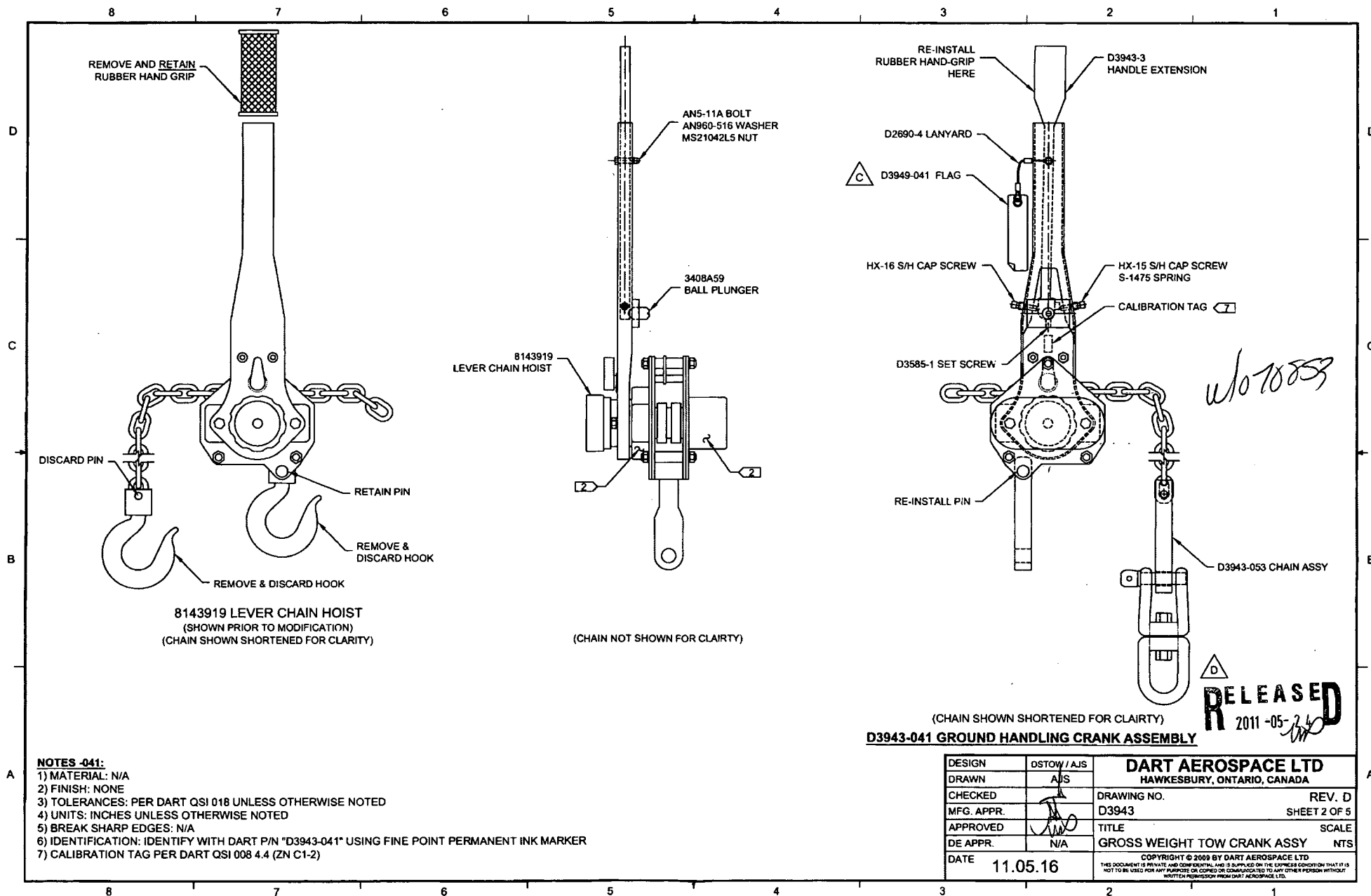
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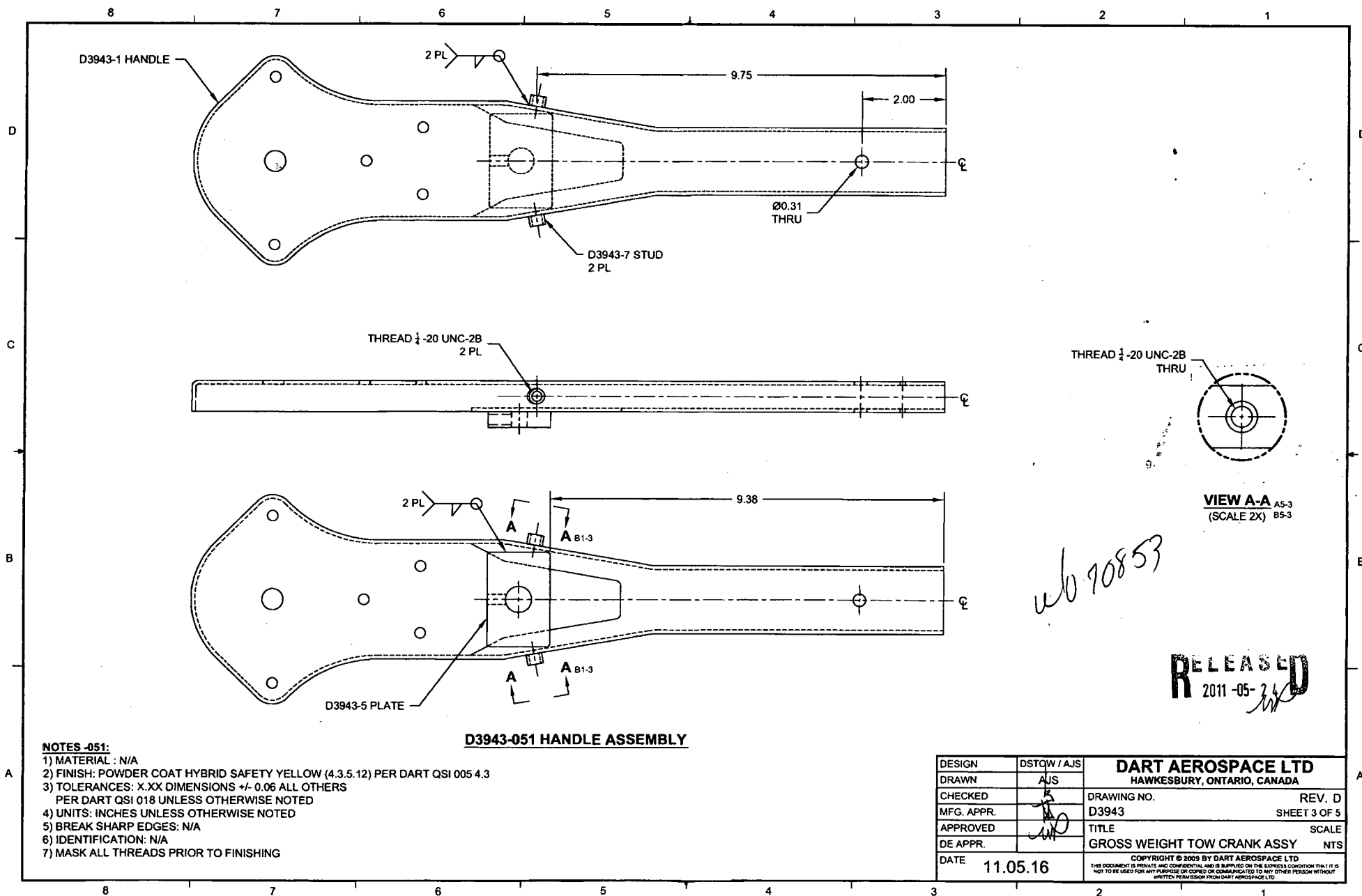
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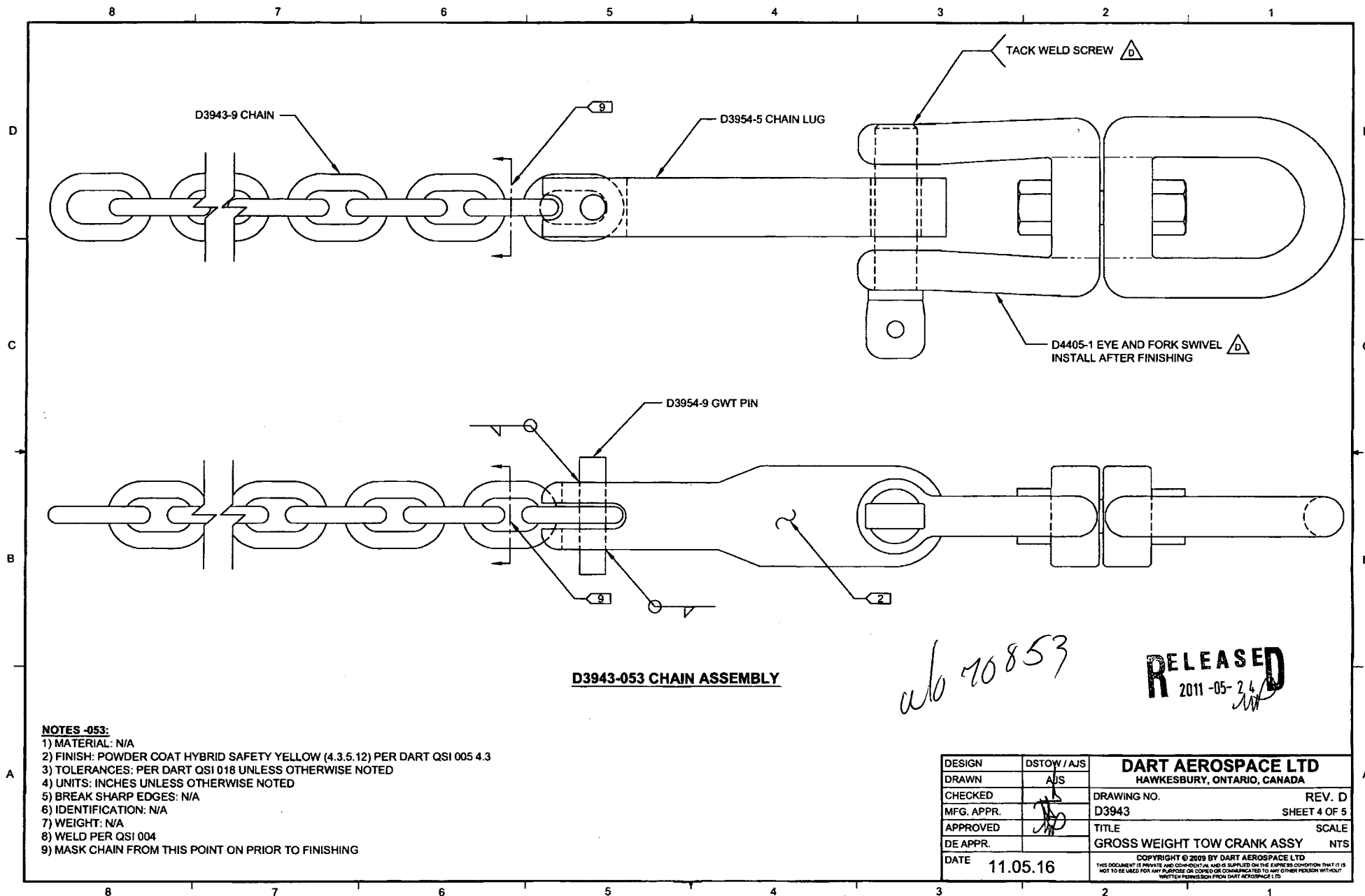
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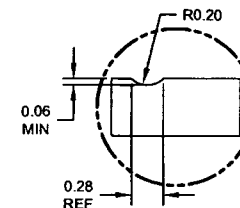
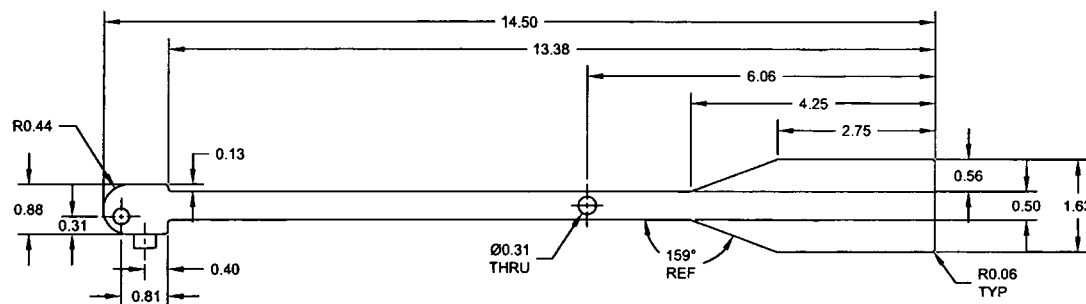
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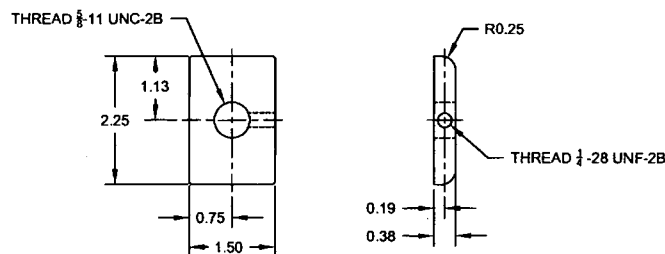
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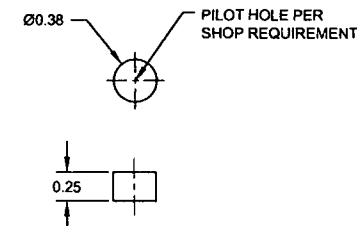
8 7 6 5 4 3 2 1



D3943-3 HANDLE EXTENSION



D3943-5 PLATE



D3943-7 STUD
(SCALE 2X)

NOTES -11/-13:

1) MATERIAL -3 & -5: MILD STEEL, SHEET
AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-S

OR: MILD STEEL, BAR
AISI 1010-1025 OR ASTM A36/A366/A569/A570
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-B

-7: MILD STEEL, ROUND BAR
AISI 1018-1025
PER MIL-S-7097
REF DART SPEC M1018-R

2) FINISH: POWDER COAT HYBRID SAFETY YELLOW (4.3.5.12) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A

DESIGN	DSTOW / AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3943	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		GROSS WEIGHT TOW CRANK ASSY	NTS
DATE	11.05.16	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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2011-05-24

8 7 6 5 4 3 2 1

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